

Date: Wednesday, 11/21/2007 12:44:06 PM
User: Kim Johnston

Process Sheet

3

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SKID TUBE ASSEMBLY
Job Number : 35905A	
Estimate Number : 12520	
P.O. Number :	Part Number : D205634045
This Issue : 11/21/2007 S.O. No. :	Drawing Number : D2580 REV D
Prsht Rev. : NC	Project Number : N/A
First Issue : 1 / Type : LANDING GEAR	Drawing Revision : D
Previous Run : 33274	Material :
Written By :	Due Date : 1/15/2008 Qty: 1 Um: Each
Checked & Approved By : <u>07.11.21</u>	
Comment : Est Rev: C Revised Steps 06-09-06 JLM	
Est Rev: D Added SS Wearplates & Gaskets 07-07-09 JLM	

Additional Product

Job Number:



Scrap

Seq. #: Machine Or Operation: Description :

1.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy D205-634 bluefile & type labels per PPP D205-634-045 CHG002

NIA

2.0

D25001190

Extn -1' Beam Tube 4"



Comment: Qty.: 1.0400 Each(s)/Unit Total : 1.0400 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2500-1-190

Skid Tube Extrusion

34729

SL 7-11-27

3.0

D2596

205 Web



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2596

205 Web

35816

SL 7-11-27

4.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1- Inspect mat'l D2500-1-190 for damage

2-Cut D2500-1-190 per Dwg D2580 if necessary Debur ends

3-Drill pilot holes using drill jig DT 8149

4-Acid etch and Alodine tube per QSI 005 4.1

SL 7-11-26

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: SKID TUBE ASSEMBLY

Job Number: 35905A

Part Number: D205634045

Job Number:



Seq. #

Machine Or Operation:

Description:

5-Open holes to 0.500" as per Dwg D2580 without cutting fluid

6-Countersink holes as per Dwg D2580 without cutting fluid

7-Deburr and blow out all chips from inside of tube

8-Bond web in place per QSI 015. Allow 12 Hrs. cure time before cutting

Pick:

Qty Part Number Description Batch

A/R Sikaflex-291 105468

Sikaflex expire date: 8-7-1

Start Time: 4:00 Date: 7-11-27

Fin Time: Date:

SL 7-11-27

SL 7-11-27

5.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

1-Bend as per program D2580.C on CNC Bender and Folio FT009

2-Cut tubes as per Dwg. D2580

DP 8-1-22

EL 7-11-28

6.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Ph

Comment: LANDING GEAR RESOURCE 1

1-Deburr ends after cutting. Remove alodine from around holes

2-Drill extra fwd hole as per DEO 9183 using drill jig DT8461

3-Drill extra middle hole as per DEO 9183 using drill jig DT8462

4-Drill pilot holes for aft cap using DT8215. ***DO NOT OPEN TO FINISH SIZE***

5-Drill extra aft holes as per DEO 9183 using drill-jig DT8463 locating from aft cap hole and aft saddle hole.

BE 08/01/28

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Handwritten signature/initials

15 holes

30-7/8"

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D205-634-045 PAR #: NA Fault Category: Prod/Landing Gear NCR: Yes No DQA: AD Date: 08/02/08
 QA: N/C Closed: AD Date: 08 02 08

NCR: <u>3 5905A</u>		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				
<u>08/01/08</u>	<u>5.0</u>	<u>Tube is slightly over Bent by 1.5" over nominal R.C. Bender</u>	<u>PH PER QSI 042 01.02.05</u>	<u>PART IS SCRAP SINCE AT NOMINAL HEIGHT PART WOULD BE 2.5" SHORTER</u> <u>SCRAP AND DESTORY SEE ATTACHED</u>	<u>DB</u> <u>8-2-7</u>	<u>AD 0207</u>	<u>PH PER QSI 042 08.02.05</u>	<u>AD</u> <u>08/01/08</u>	

NOTE: Date & initial all entries

height = 13.0"
SPRINGS & DYS = 30.75"

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Drawing Name: SKID TUBE ASSEMBLY

Job Number: 35905A

Part Number: D205634045

Job Number:



Seq. #:	Machine Or Operation:	Description :
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8.0	D25763	Step (Machining Detail)
-----	--------	-------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2576-3	Step	

9.0	D2579	Crossbolt Spacer
-----	-------	------------------



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
24	D2579	Spacers	

10.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
------	-------------	------------------------------



Comment: LARGE FABRICATION RESOURCE 1

1-Prepare tube for welding D2576-3 Step Remove alodine as required.

2-Weld step D2576 as per Dwg. D2580 and QSI 004

A/R Aluminum Rod

3-Weld crossbolt spacers D2579 as per Dwg. D2580 and QSI 004. For D2579

side, pass 3/8" drill, weld other side, pass 3/8" drill

A/R Aluminum Rod

spacers, weld one

4-Grind welds as per Dwg D2580 Grind flush ridge made from bending

5-Drill holes for wearplates using DT 8217 Open holes to 19/64", adjust stopper not to hit web. Deburr

6-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580. Deburr holes

*****DO NOT COUNTERBORE EXTRA HOLES PUT IN AT STEP 13,14 AND 15 (LEAVE AT 0.384"Ø AS PER DEO 9183)****

7-Open aft cap holes to #6 Drill bit. Deburr

8-Drill pilot holes for Tow ring using DT8091, open to .640" and Deburr

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Process Sheet

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Drawing Name: SKID TUBE ASSEMBLY

Job Number: 35905A

Part Number: D205634045

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

13.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

14.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

[Signature] Powder Coat ****GREEN****Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

16.0

D2855

Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cap

Batch: _____

17.0

AN35A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: _____

18.0

AN960JD10L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: _____

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Part Number: D205634045

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

ALS71032130

Insert



Comment: Qty.: 50.0000 Each(s)/Unit Total : 50.0000 Each(s)

Insert

Batch: _____

20.0

AN3C4A

BOLT



Comment: Qty.: 50.0000 Each(s)/Unit Total : 50.0000 Each(s)

BOLT

Batch: _____

21.0

D356613

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: _____

22.0

D35665

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: _____

23.0

D35661

GASKET



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

GASKET

Batch: _____

24.0

D356413

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: _____

25.0

D356411

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: _____

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Drawing Name: SKID TUBE ASSEMBLY

Job Number: 35905A

Part Number: D205634045

Job Number:



Seq. #:

Machine Or Operation:

Description :

26.0

D35649

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
WEARSHOE
Batch: _____

27.0

D35645

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
WEARSHOE
Batch: _____

28.0

D25943

O-Ring



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)
O-Ring
Batch: _____

29.0

D25941

Plug



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)
Plug
Batch: _____

30.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install inserts & wearplates as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates

A/R Sikaflex-291 _____

Sikaflex expire date: _____

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive

A/R Sikaflex-291 _____

Sikaflex expire date: _____

5-Wing Walk as per Dwg D2580 and QSI 005 4.4

Batch: _____

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
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Job Number: 35905A

Part Number: D205634045

Job Number:



Seq. #:

Machine Or Operation:

Description :

31.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

32.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-634-045

Location: _____

PPP Rev: _____

33.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Kim Johnston 2007/12/07



W

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN #	DRAWN BY RH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

RELEASED
07-06-28 #

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL $\varnothing 0.297$ HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:
SEE NOTES ON
PAGE 2 FOR D2580-041 AND
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 35905A

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RELEASED
07-06-28

Diagram illustrating the grinding locations for the D2576-3 step. The diagram shows a cross-section of the step with the following labels:

- GRIND FLUSH (4 PLACES)
- GRIND FLUSH
- D2576-3 STEP
- LOCATION RIDGE ON UNDERSIDE OF D2576
- $\frac{1}{16}$

#0.208
 DRILL PRIOR TO D2855 CAP
 INSTALLATION (2 PLACES)

AN3-5A BOLT (1)
 AN960J10L WASHER (1)
 (2 PLACES)

D2855 CAP

0.40

SHOP COPY
 RETURN TO
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 WITHOUT NOTICE

NO. 35905 A

D2579 SPACER

D2596 WEB (REF)

D2579-1032-130 (REF)
 (TYP 50 PLACES)

SEAL WITH
 SIKAFLEX-241/-291

SECTION D-D
 SCALE 5:24

AFTER PERFORM
 1. CHAIR
 2. INSE
 3. WEL
 4. C'BO

AFTER PERFORM
1. CHAMFER
2. INSERT
3. WELD

AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C-BORE D2579 SPACER TO Ø0.437 X 1.00 DEEP

37.50
DISTANCE TO AFT END
OF D2596 WEB
3 7
1.750 1.750
Ø0.508 (TYP.)
(40 PLACES)
REFER TO DETAIL A
REFER TO DETAIL A
8.750
17.375
26.000
34.188
57.313 (REF)
7 EQUAL SPACES
8.188 PITCH
38.0
91.500
190.0
(D2500-1)

WELD AS PER DETAIL B

BLACK ANTI-SKID TO 0.5 ABOVE LOCATION RIDGE

BLACK ANTI-SKID TOP OF STEP TO 0.5 ABOVE BOTTOM EDGE

0.5

1.5

1.5

D

8

1.5

1.5

1.5

P P P P P P P

REFER TO DETAIL C

D3566-1

D3566-5

D3566-1

D3566-13

D3564-11

D3564-5

D3564-9

D3564-13

AN3C4A BOLT (1)

AN560C10L WASHER (1)

(50 PLACES)

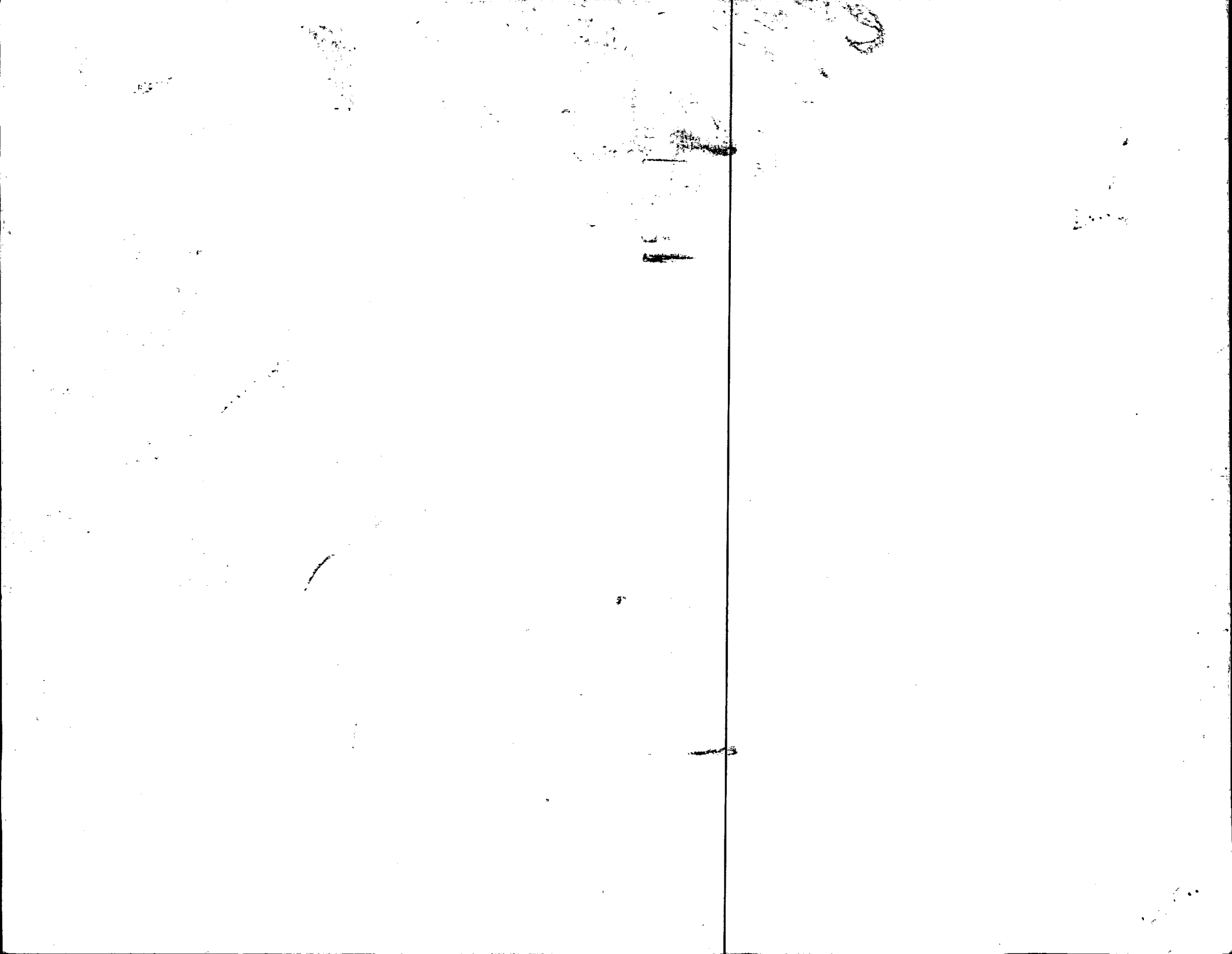
DESIGN	1	DRAWN BY	
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i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

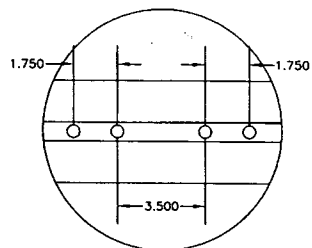
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LAWRENCEVILLE, ONTARIO, CANADA

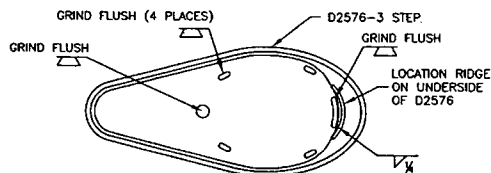
DRAWING NO.	REV. D
D2580	SHEET 2 OF 3
TITLE	SCALE
205 SKIDTUBE ASSEMBLY	1:24



DETAIL E
SCALE 5:24

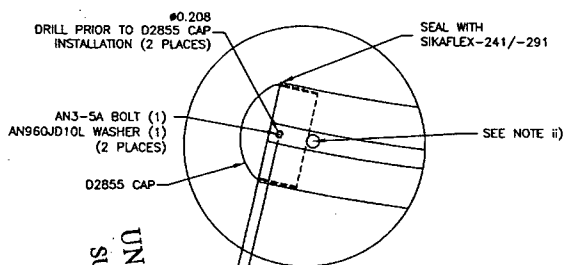


DETAIL F
SCALE 5:24

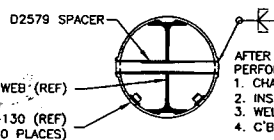


RELEASED
07.06.28

DETAIL G
SCALE 5:24

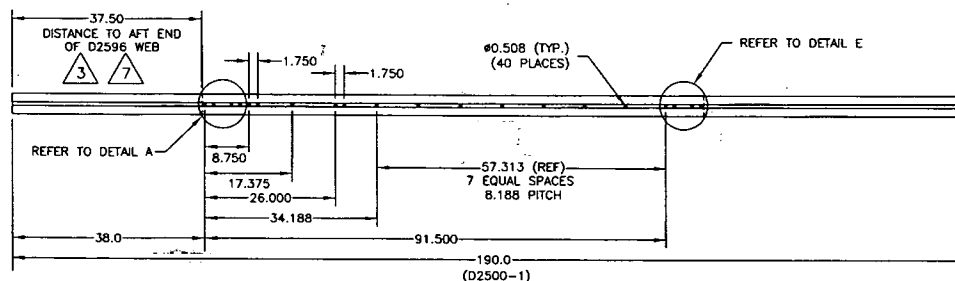


SECTION H-H
SCALE 5:24

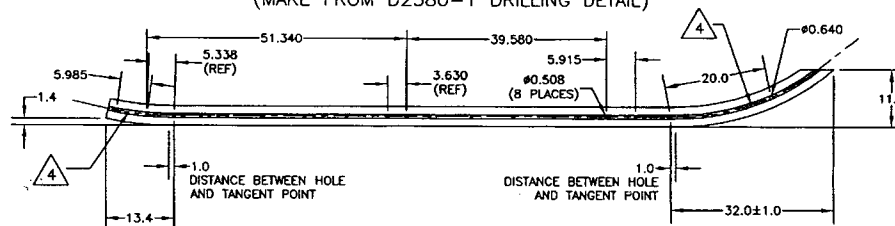


AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR #0.508 HOLES ONLY:
1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE D2579 SPACER TO #0.437 X 1.00 DEEP

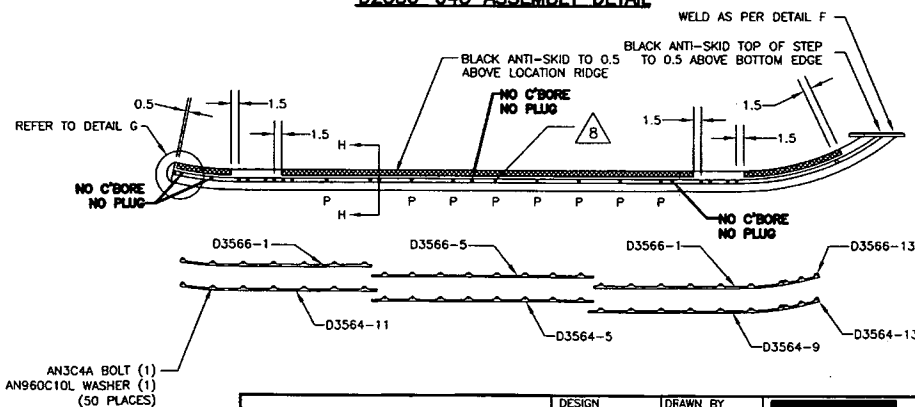
D2580-1 DRILLING DETAIL



D2580-5 BENDING AND CUTTING DETAIL
(MAKE FROM D2580-1 DRILLING DETAIL)



D2580-045 ASSEMBLY DETAIL



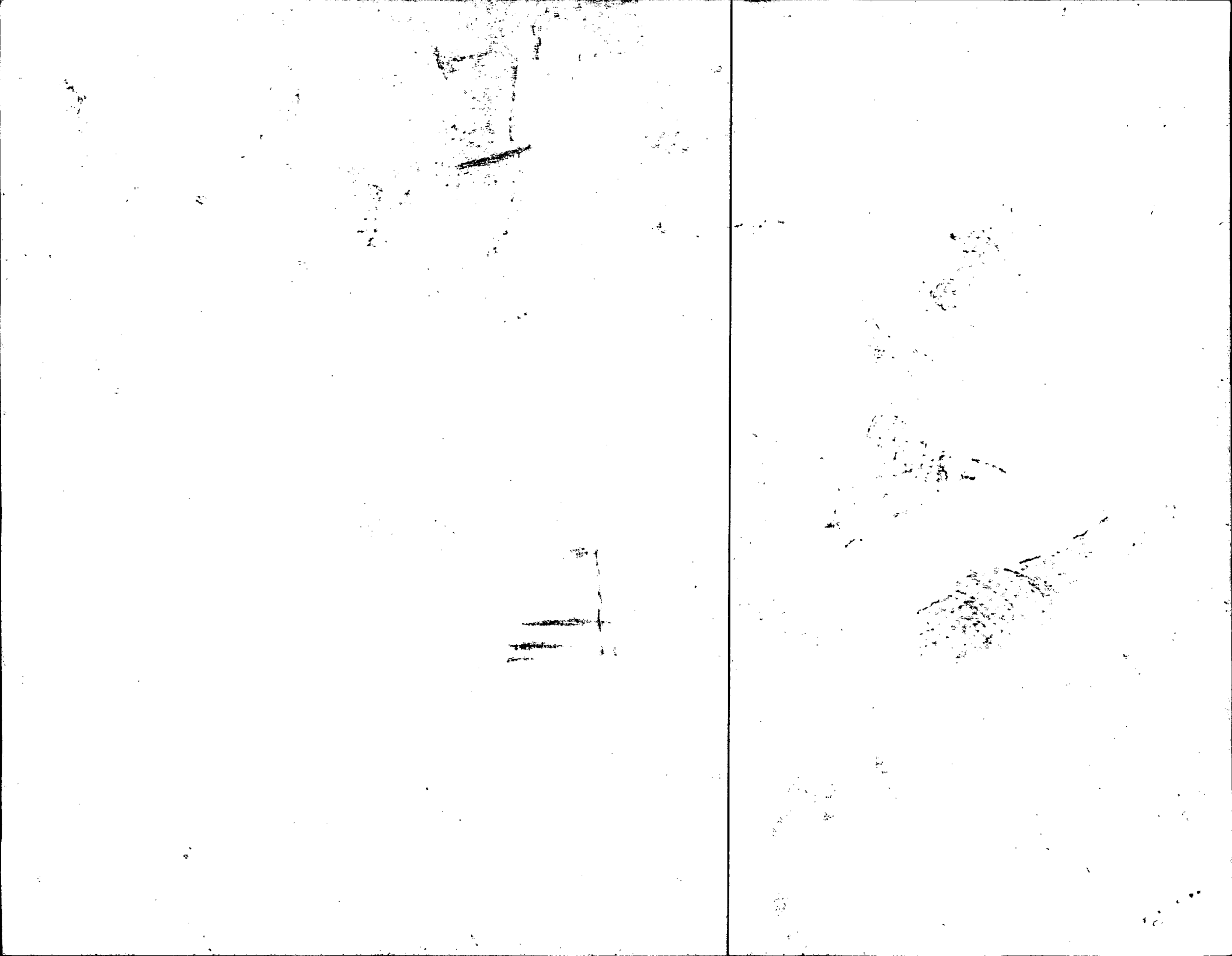
D2580-045 NOTES

- i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
- ii) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

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DESIGN RH	DRAWN BY RH	DART	DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA
CHECKED H	APPROVED H	DRAWING NO. D2580	REV. D SHEET 3 OF 3
DATE 07.02.27	TITLE 205 SKIDTUBE ASSEMBLY	SCALE 1:24	



Peter Hum

From: David Shepherd [dshepherd@dartaero.com]
Sent: February 5, 2008 4:07 PM
To: 'Peter Hum'
Subject: RE: D205-634-045; height and length

I recommend that we scrap this tube.

David

From: Peter Hum [mailto:phum@dartaero.com]
Sent: Tuesday, February 05, 2008 10:51 AM
To: 'David Shepherd'
Subject: D205-634-045; height and length

David,

Production is bending skid tubes for D205-634-045. There is a deviation on the height of the forward bend, in turn this caused a deviation on the length from the forward most saddle hole.

The nominal dimension for the length is 32" and height is 11.5". The deviated tube is 30.875" long and 13" high. The tangent point has remained the same

This is a non-structural area of the tube and a cosmetic issue. I've done a layout showing my proposed solution of cutting the height by 0.75" (half the deviation height).

This will leave the tube shorter by 1.9" from at the front and 0.75" higher.

I've attached a sketch describing the above.

I realize I can deviate this by myself, however I'm not sure how to deal with cosmetic issues (i.e. knowing how much is okay).

Is my proposed solution acceptable?

Thanks
Peter

No virus found in this incoming message.

Checked by AVG Free Edition.

Version: 7.5.516 / Virus Database: 269.19.20/1260 - Release Date: 2/5/2008 9:44 AM

No virus found in this outgoing message.

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Version: 7.5.516 / Virus Database: 269.19.20/1260 - Release Date: 2/5/2008 9:44 AM

05/02/2008

